

Date: Friday, 05/09/2008 7:13:25 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOOR PROTECTOR AFT LH
Job Number :	41851		
Estimate Number :	11228		
P.O. Number :		Part Number :	D32813
This Issue :	05/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3281 REV. D
First Issue :	1/1	Project Number :	N/A
Previous Run :	40474	Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :		Due Date :	12/09/2008
Comment :	Est Rev. A 04.07.01 New issue KJ/JLM Est Rev. B 07.08.07 Thermoform in house DL Est Rev. C 08.02.06 To reflect updated Dwg. DL Est Rev. D 08.04.15 Material Change DL		

Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
-----	-----------------	-------------------------



Comment: Qty.: 4.3330 sf(s)/Unit Total: 21.6650 sf(s)
 GE PLASTICS LEXAN SHEET

Material Batch Number M106751

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks

BB

08/09/05

X3

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 009

Dwg. Rev. DFolio Rev. B

BB

08/09/05

X3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/09/05

X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 7:13:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT LH

Job Number: 41851

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BD 08/09/08 X3

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BD 08/09/09 X3

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/09 X3

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 273

188 08/09/10 X3

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10 X3

Job Completion



mf 08-09-10

DART AEROSPACE LTD		Work Order: 41851
Description: Floor Protector, Aft LH		Part Number: D3281-3
Inspection Dwg: D3281	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BS

Date: 08/09/08

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.750	✓			
17.1	+/-0.100	17.125	✓			
14.3	+/-0.100	14.3	✓			
0.95	+/-0.030	.975	✓			
0.25	+/-0.030	.255	✓			
3.1	+/-0.100	3.125	✓			
0.050	Min	.067	✓			
0.070	+/-0.010 Min	.91	✓			

Measured by: BS

Date: 08/09/08

Audited by:

Date: 08/09/08

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	

DART AEROSPACE LTD		Work Order: 41851
Description: Floor Protector, Aft LH		Part Number: D3281-3
Inspection Dwg: D3281	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/09/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.8	✓			
17.1	+/-0.100	17.125	✓			
14.3	+/-0.100	14.3	✓			
0.95	+/-0.030	.977				
0.25	+/-0.030	.257	✓			
3.1	+/-0.100	3.1	✓			
0.050	Min	.062	✓			
0.070	+/-0.010 Min	.079	✓			

Measured by: BB

Date: 08/09/09

Audited by: S

Date: 08/09/09

Prototype Approval:

N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <u>A</u>	<u>BB</u>

DART AEROSPACE LTD		Work Order: 41851
Description: Floor Protector, Aft LH		Part Number: D3281-3
Inspection Dwg: D3281	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/09/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.75	✓			
17.1	+/-0.100	17.11	✓			
14.3	+/-0.100	14.27	✓			
0.95	+/-0.030	.968	✓			
0.25	+/-0.030	.245	✓			
3.1	+/-0.100	3.1	✓			
0.050	Min	.094	✓			
0.070	±0.010	.125	✓			
	M.I.D					

Measured by: BB

Date: 08/09/09

Audited by: S

Date: 08/09/09

Prototype Approval:

N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	